

Work Order ID 129855

February-23-15 10:27:26 AM

129855

Page 1

Item ID: D3484-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Light Fairing Assembly, LH
 Start Date: 2/23/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1502-25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3484	Rev F

100 0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 27595

Make as per Dwg D3484

Material release note is required

GFI

MLJ 1502-27 (10)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

10X SP15-04-6

115

Weld per dwg A/R Aluminum rod Batch: _____

0.00

115

Large Fab

Memo

0.00

Large Fab

Touch up weld if necessary

GFI

9-09
150406

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Page 2

Hand Finishing

DAS
9
9-8

(15) 15.04.06

DAS
9
9-8

(10) 15-04-06

10 15-4-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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February-23-15 10:27:26 AM

Item ID: D3484-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tail Light Fairing Assembly, LH

Stop *NS2*

Start Date: 2/23/15 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 2/23/15 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC7-Inspect Chemical Conversion Coat

0.00

150

OC

Memo

0.00

Quality Control

(10) 15.04.08

160

0.00

160

Small Fab

Memo

0.00

Small Fab

1-Install Nut Plates as per Dwg D3484

10 FF APR 08 2015

170

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

170

QC

Memo

0.00

Quality Control

10

DAS
38
9-89
APR 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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February-23-15 10:27:26 AM

Item ID: D3484-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tail Light Fairing Assembly, LH

Stop *NS2*

Start Date: 2/23/15 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 2/23/15 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

200

0.00

Packaging

Memo

Packaging

Identify as per dwg and Stock
Location: 510

Location

DAG
6
9-8

220

QC21- Final Inspection - Work Order Release

0.00

220

0.00

QC

Memo

Quality Control

MLJ 15-04-13

MF

15-4-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

February-23-15 10:27:26 AM

Page 1

Work Order ID: 129855

129855

Parent Item: D3484-041

D3484-041

Parent Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-04-11 JLM

IPP Rev:B 08-01-24 chg rivet to CR1122-3-025 DD verf:EC IPP Rev:C

11.03.07 added weld touch up DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3484-041P		Purchased	No			110	Each	0.0000	1	10			
D3484-041P									**				
Tail light Fairing													
MS21069-04		Purchased	No			160	Each	7.0000	2	20			
MS21069-04									**				
ANCHOR NUT													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST301	131677		7		13			
					m129472			7		7			
CR1122-3-02.5		Purchased	No			160	Each	46.0000	4	40			
CR1122-3-02 5									**				
RIVET													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					GA			46					
					m127432			46		40			

16x SP15-04-6.

FF APR 08 2015

FF APR 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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8

7

6

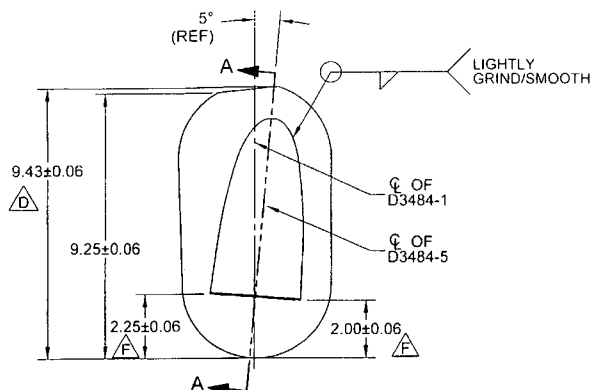
5

4

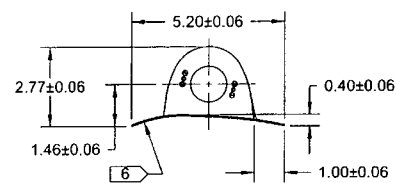
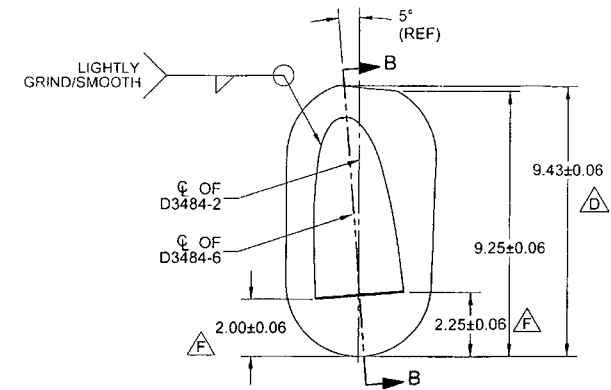
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2

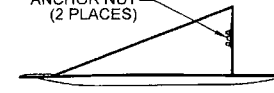
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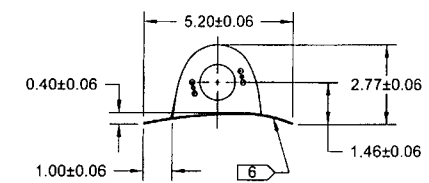
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4		CR1122-3-02.5	RIVET
2		MS21069-04	ANCHOR NUT



SECTION A-A

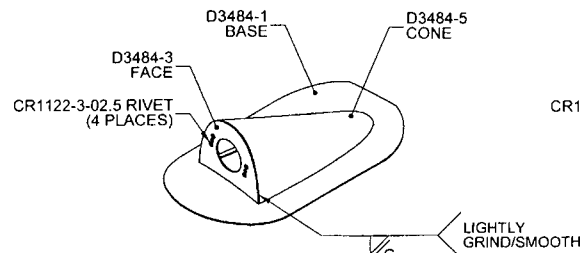
INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B

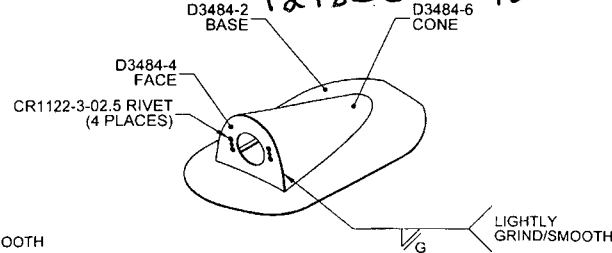


D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

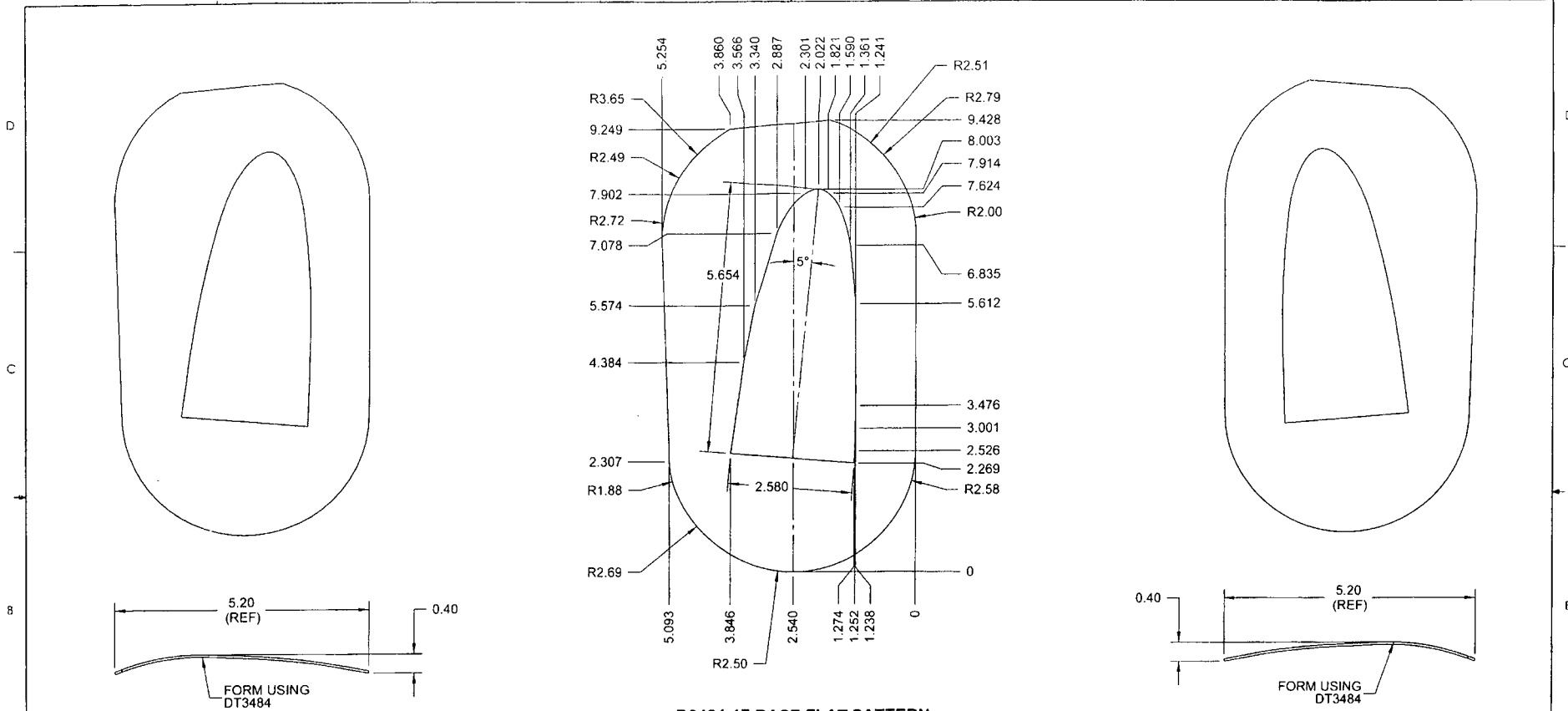
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

RELEASED
09/24/04

F	UPDATE MATERIAL SPEC. ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1	09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB 08.01.03
D	CORRECT D3484-1F	MB 06.06.22
C	RE-DESIGN D3484-3F/5F	MB 06.04.20
B	RE-DESIGN	MB 06.02.21
A	NEW ISSUE	MB 05.11.29
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.31	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D3484		REV. F
TITLE TAIL LIGHT FAIRING		SHEET 1 OF 4
SCALE 1:4		
COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIALITY IS NOT APPLICABLE. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1



D3484-1 BASE
(MAKE FROM D3484-1F)

D3484-1F BASE FLAT PATTERN

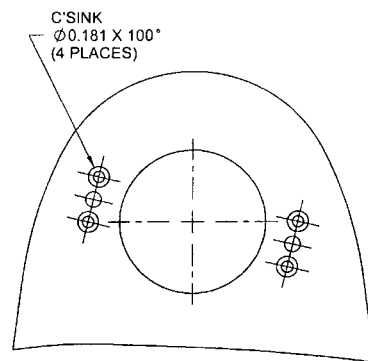
D3484-2 BASE
(MAKE FROM D3484-1F)

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

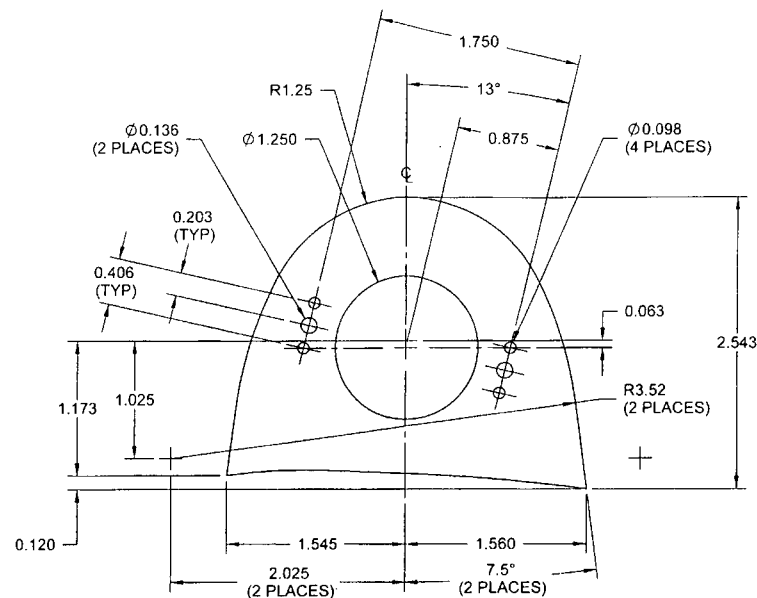
RELEASED
07/01/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

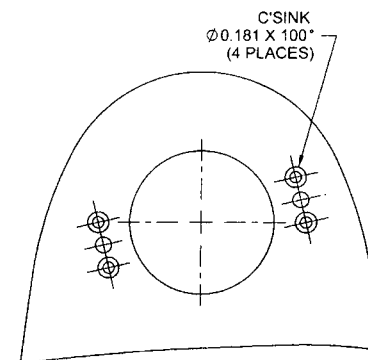
8 7 6 5 4 3 2 1



D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

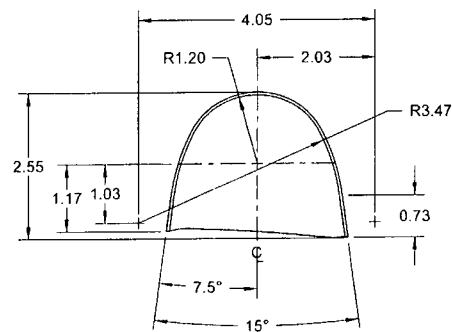
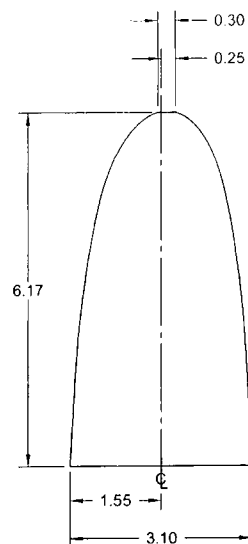


D3484-4 FACE
(MAKE FROM D3484-3F)

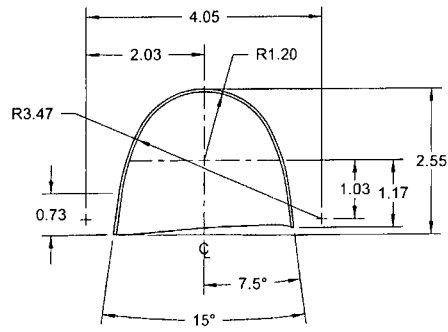
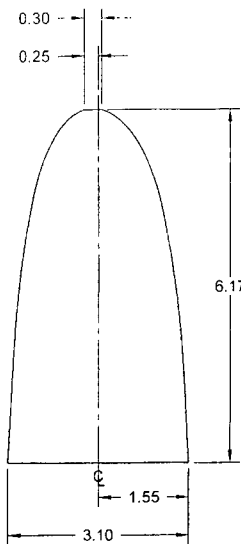
- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

RELEASED
09/03/31

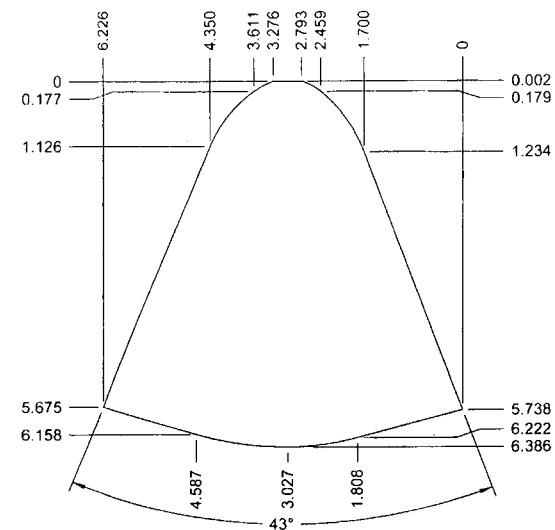
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3484-5 CONE
(MAKE FROM D3484-5F)



D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

RELEASED
09/04/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3484	REV. F
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27595**

Purchase Order Date 2/27/2015

PO Print Date 2/27/2015

Page Number 1 of 2

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3484-041P AS PER DWG.D3484 REV.F B129855	Tail light Fairing	3/20/2015 Yes 3/20/2015		10.00 Each	\$280.00	\$2,800.00
Line Total:							\$2,800.00
2	D3484-042P AS PER DWG.D3484 REV.F B130211	Tail Light Fairing	3/20/2015 Yes 3/20/2015		10.00 Each	\$280.00	\$2,800.00
Line Total:							\$2,800.00

Note:

2/27/2015



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

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BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE				N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR	DY	MO	AN	YR	
01	04	15		0557091	1/1

VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO



EXFO TELECOM EQUIPMENT
(SHENZHEN) LTD.
3RD FLR. BLDG. 10, YU SHENG
IND. PRK # 467 NATL HIWAY
107, XIXIANG
518126
CHINA

PO SHUN TRANSPORTATION COMPANY
UNIT 1211, 12TH FLR.,
GRAND TECH CENTER,
8 ON PING ST,
SHATIN N.T., HK
CHINA

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
EXFC		GFI-0460	0299497	20198026
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION		
49	1067200.(MC6809)	COVER FOR FG-750 EXFO FEDEX ACCOUNT IS 1984 42976 PO NUMBER MUST APPEAR ON FEDEX WAYBILL. MARK EXFO ON THE SHIPPING BOX. <i>SP15-21-6</i>		

EXPÉDITEUR / SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

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BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO - MO	AN - YR			
01	04	15	0557092		1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

EXFO TELECOM EQUIPMENT
(SHENZHEN) LTD.
3RD FLR.BLDG.10, YU SHENG
IND.PRK # 467 NATL HIWAY
107, XIXIANG
518126
CHINA

PO SHUN TRANSPORTATION COMPANY
UNIT 1211, 12TH FLR,
GRAND TECH CENTER,
8 ON PING ST,
SHATIN N.T., HK
CHINA

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
EXFC	GFI-0460	20197476	FED EX.

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
10	1062936 (MC6743)	ESCALADE SUPPORT BRACKET EXFO FEDEX ACCOUNT IS 1984 42976 PO NUMBER MUST APPEAR ON FEDEX WAYBILL.MARK EXFO ON THE SHIPPING BOX.

SP15-04-6

EXPÉDITEUR / SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

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BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO	PAGE
JR	DY	MO	AN	YR
31	03	15	0557071	1/1



VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART		GFI-0299	0299914	PO27595
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO		DESCRIPTION	
10	D3484041P		TAIL LIGHT FAIRING	
			ITEM 1 C OF C REQ'D	
			MFG. JOB# 0299914-001 QTY 10 pcs	
			DUE DATE: 25 March 2015	
			GAS-able	

EXPÉDITEUR
SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 11 OUR JOB NO 0299914 SHIPPING MEMO 0557071

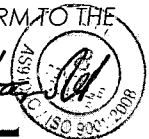
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>10 PCS</u>	<u>PO27595</u>	<u>D3484041P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>	<u>F</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>AL 6061-T0 (AMS-QQ-A-250/11)</u>		<u>TW METALS / KAISER ALUMINUM</u>			<u>656402A5</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>WELD FOLOWING PARTS TOGETHER PER DART QSI 004(1) D3484-1 (BASE LH),(1) D3484-3 (FACE LH),(1) D3484-5 (CONE LH)</u>	<u>GFI</u>	<u>N/A</u>
3	<u>REF. GFI MANUFACTURING JOB NUMBER 0299914-001 (10 PCS)</u>		
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 31 MARCH 2015

G.F.I. Q.C. REP. 





O'Neal High-Performance Metals Group

175 TUBEWAY

FOREST PARK

GA 30297

Tel: 404-361-5050

FAX: 4043617052

CERTIFICATE OF COMPLIANCE

Your Order Number: 0084310

Our delivery receipt Number: 70546233

Date: 6/19/14

This is to certify that the material shipped against the above order on the above delivery receipt, consisting of:

Quantity: 68.152 LB

Line Number: 1

Grade: 60610 ALM SHT STENCILLED .0500

Part #: AS05148144PM

Heat Number: 656402A5

Specification:

Complies in all respects with the item description.



BY:

Javice Clark

Authorized Test Department Clerk

SHIP TO:
TW METALS
1200 BLAKE DRIVE
WICHITA, KS 67219

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

SOLD TO:
TW METALS INC
THE ARBORETUM
760 CONSTITUTION DRIVE
EXTON, PA 19341

Serial Number
4326313

CUSTOMER PO NUMBER: M49306569		WORK PACKAGE:	CUSTOMER PART NUMBER: 76409		SHIP RUN/LOAD: 102866/7	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1164776	LINE ITEM: 1	SHIP DATE: 5-MAR-2014	ALLOY: 6061	CLAD: BARE	TEMPER: O	PRODUCT DESCRIPTION: HT Flat Sheet	
WEIGHT SHIPPED: 8492 LB	QUANTITY: 251 PCS EST.	TRUCK B/L #: 2046715	GAUGE: 0.0500 IN (1.2700 MM)		DIAMETER/WIDTH: 48.000 IN (1219.2 MM)	LENGTH: 144.000 IN (3657.6 MM)	

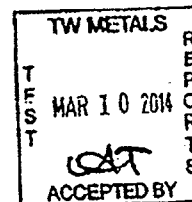
MHU 1749653: LOT 656402A5: 118 pieces;
MHU 1762050: LOT 656494A2: 133 pieces;

Certified Specifications

AMS 4025/RevL
CMMP 025/RevU

ASTM B 209/Rev10

CMMP 019/RevD



Test Code: 1925

Test Results

Lot: 656402A5 Cast 023

Drop 78

Ingot 2

Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile: Temper
O

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
18.6 : 18.7
(128 : 129)

Yield KSI (MPA)
7.4 : 7.5
(51 : 52)

Elongation %
25.3 : 25.8

T42

LT / 2 (Min:Max)

35.2 : 35.8
(243 : 247)

17.6 : 17.9
(121 : 123)

22.9 : 25.0

T62

LT / 2 (Min:Max)

45.2 : 45.5
(312 : 314)

37.6 : 38.1
(259 : 263)

13.4 : 13.4

(ASTM E1251)

Chemistry:
Actual(wt%)

SI
0.71

FE
0.5

CU
0.31

MN
0.08

MG
1.1

CR
0.18

ZN
0.06

TI
0.02

V
0.01

ZR
0.00

OTHER
TOT 0.05





Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4326313

Lot: 656494A2 Cast 023

Drop 87

Ingot 1

Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	18.2 : 18.3 (125 : 126)	7.5 : 7.7 (52 : 53)	24.9 : 25.7
	T42	LT / 2 (Min:Max)	37.1 : 37.5 (256 : 259)	18.5 : 18.8 (128 : 130)	23.1 : 24.1
	T62	LT / 2 (Min:Max)	47.3 : 50.3 (326 : 347)	41.2 : 43.3 (284 : 299)	12.9 : 13.2

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.77	0.5	0.32	0.07	1.1	0.19	0.08	0.03	0.01	0.00	TOT 0.05

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN(wt%)	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

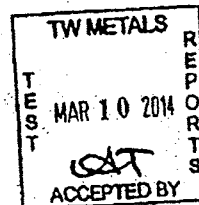
Aluminum Remainder

ORDER COMMENTS

FAR BAA (FAR 52.225-1 BUY AMERICAN
ACT-SUPPLIES)
DFARS BAA (DFARS 252.225-7001 BUY
AMERICAN ACT & BAL. OF PAYMENTS PROG
FAR TAA (FAR 52.225-6 TRADE AGREEMENTS)

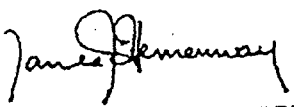
TEST NOTES

6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS
4027 also meets applicable requirements of AMS-QQ-A-250/11,
Rev. A.



CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:
* has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
* was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
* has been thermally processed in compliance with AMS 2772, where applicable.
* is mercury free, within the limits of detection of ASTM E1251 (< = 1ppm).
* is in compliance with RoHS 2, European Union Directive 2011/65/EU.
* is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
* is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.


JAMES HEMMENWAY, LABORATORIES SUPERVISOR

